

Date: Thursday, 14/05/2009 3:41:12 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACERS (5/16 THICK)
Job Number	: 47964		
Estimate Number	: 10248		
P.O. Number	:	Part Number	: D2022103
This Issue	: 14/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2022 REV. -
First Issue	: / /	Project Number	: N/A
Previous Run	: 44353	Drawing Revision	: -
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 21/05/2009
Checked & Approved By	: <u>Julie Dawson</u>	Qty:	200
Comment	: Est D 02.03.07 Now made in house NG	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0329 f(s)/Unit Total: 6.5730 f(s)

6061T6 Round Bar .750"

Material: 6061-T6 (QQ-A-225/8)x.750Ø bar
 (M6061T6RO.750) Batch: M110791

SA 09/05/19

(6A)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1- Note: .323 (P) Dia drill.

2-Turn Blank as per FolioFA207

3-Tumble & deburr any sharp edges as per dwg

SA 09/05/19

(204)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/05/19

(204)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/05/19

(204)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST9

SA 09/05/20 (204)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/05/2009 3:41:13 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (5/16 THICK)

Job Number: 47964

Part Number: D2022103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/20 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

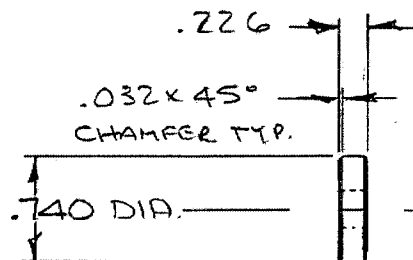
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
970119 BW



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/B)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12107



D2022

D2022-103	SPACER 5/16	ALUM 6061-T6	QQ-A-250/B
D2022-101	SPACER 1/4	ALUM 6061-T6	QQ-A-250/B

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DART AERO ACCESSORIES INC				
CONTRACT NO.	DATE	CUSTOMER		
DRAWN BRADLEY	2008/10			
DESIGN BRADLEY				
STRESS				
CHECKED				
CLIENT				
CODE		D2022		REV.
SCALE 1:1		SHT 1 OF 1		

REVISION	APPROVAL	APPROVED	DESCRIPTION OF CHANGE														
<p>THE DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.</p> <p>REQUIREMENTS - UNLESS OTHERWISE SPECIFIED</p> <table border="1"> <tr> <th>GENERAL</th> <th>LIMITS</th> </tr> <tr> <td>1 DIMENSIONS ARE IN INCHES</td> <td>1 TOLERANCES - JUL 2 2000</td> </tr> <tr> <td>2 SURFACE FINISHES - IN-</td> <td>200 2 010</td> </tr> <tr> <td>3 REMOVE SHARP EDGES 0.015 MAX.</td> <td>3 ANGLES 1 1/2"</td> </tr> <tr> <td>4 THREADED PER MIL - S - 7713</td> <td>4 PARALLELISM 2 005</td> </tr> <tr> <td>5 Holes PER MIL 1020</td> <td>5 PERPENDICULARITY 200 MAX</td> </tr> <tr> <td></td> <td>6 SURFACTIVITY ABOUT ALL M/C CONTACT LINES 800</td> </tr> </table> <p>REPORT ALL DISCREPANCIES - DO NOT SCALE</p>				GENERAL	LIMITS	1 DIMENSIONS ARE IN INCHES	1 TOLERANCES - JUL 2 2000	2 SURFACE FINISHES - IN-	200 2 010	3 REMOVE SHARP EDGES 0.015 MAX.	3 ANGLES 1 1/2"	4 THREADED PER MIL - S - 7713	4 PARALLELISM 2 005	5 Holes PER MIL 1020	5 PERPENDICULARITY 200 MAX		6 SURFACTIVITY ABOUT ALL M/C CONTACT LINES 800
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